

Work Order ID 85708

85708

Page 1

June-13-12 4:09:02 PM

Item ID: D3256-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Gasket

Stop ***NS2***

Start Date: 13/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 27/06/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/14* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3256	D								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3256								
<i>DEBUR BLACK .025</i>	Rev: <i>D</i>								
<i>Gasket</i>	Prog Rev: <i>D</i>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

6 0 Jm 12-6-20

6 0 Jm 12-6-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

June-13-12 4:09:05 PM

Page 1

Work Order ID: 85708

85708

Parent Item: D3256-3

D3256-3

Parent Item Name: Gasket

Start Date: 13/06/2012

Required Date: 27/06/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP B04.12.06Made in-houseKJ/JLM

IPP Rev:C ecn 1052/water jet 07-11-05 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3245		Manufactured	No			100	Each	37.5500	1.02	6.442105			
D3245									**				
Gasket													

Jm 12-6-20

Location

Loc Qty

Loc Code

MAT052

37.55

77224

37.55

77224

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DART AEROSPACE LTD		Work Order: 85708
Description: Access Panel		Part Number: D3256-3
Inspection Dwg: D3256	Rev: <i>[Signature]</i>	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
24.00 ✓	+/-0.030	24.00"	✓		MT	H301
6.10 ✓	+/-0.030	6.120"	✓		✓	mm01
11.25 ✓	+/-0.030	11.260"	✓		✓	ProdW302
10.55 ✓	+/-0.030	10.555"	✓		✓	"
1.60 ✓	+/-0.030	1.613"	✓		✓	mm01
1.50 ✓	+/-0.030	1.515"	✓		✓	"
4.15 ✓	+/-0.030	4.155"	✓		✓	"
1.30 ✓	+/-0.030	1.315"	✓		✓	"
0.65 ✓	+/-0.030	0.664"	✓		✓	"
0.65 ✓	+/-0.030	0.665"	✓		✓	"
0.45	+/-0.030	N/A				
<i>For</i> 1.50 0.83"	+/-0.030	0.828"	✓		✓	mm01

Measured by: <i>JPM</i>	Audited by: <i>[Signature]</i>	Prototype Approval: N/A
Date: 12-6-20	Date: 1206 21	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD <i>[Signature]</i>	<i>[Signature]</i>

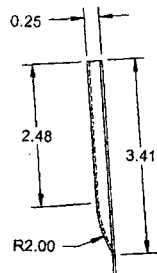
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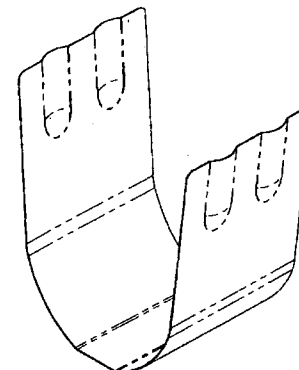
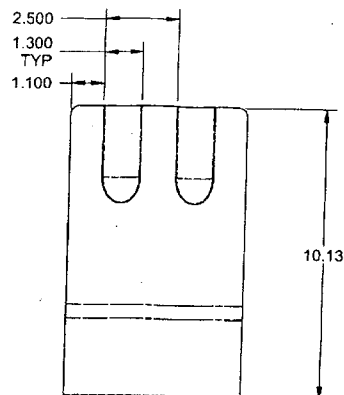
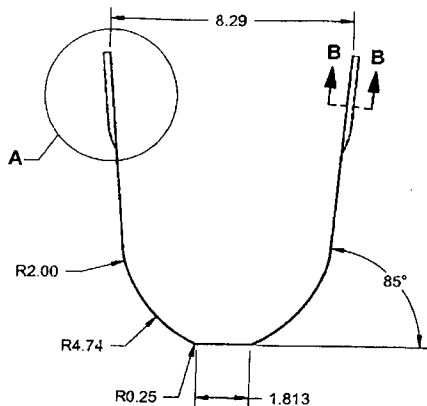
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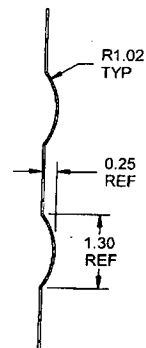
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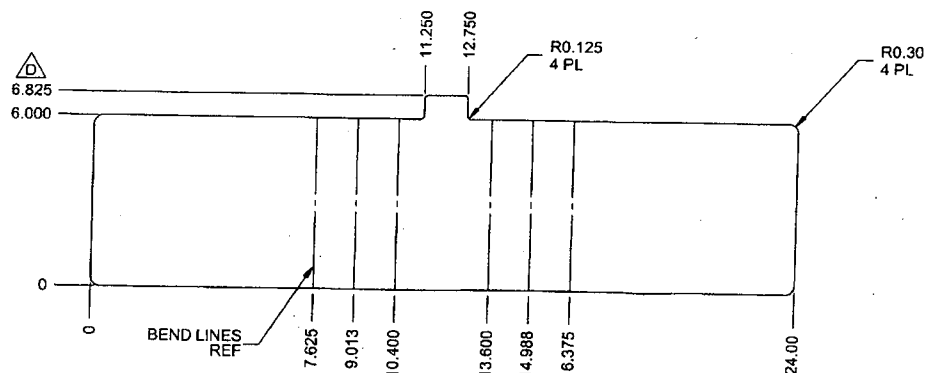
DETAIL A
SCALE 2X



D3256-1 ACCESS PANEL
(MAKE FROM D3256-1F)



SECTION B-B
SCALE 2X
(VIEW ROTATED)



D3256-1F FLAT PATTERN 1

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 0.032 THICK PER MIL-S-5019 OR AMS 5513/AMS 5524 OR ASTM A240 OR ASME SA240 REF. DART SPEC. M304S22GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3256-1" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 1.37 lbs

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85708 4LJ
12/06/14

RELEASE
2011-11-10

D	UPDATED TO COMPLY WITH QSI 043; REMOVED "FORM JOGGLE PER D3256-1T1" AND "FORM PER D3256-1T2" (SEE PREVIOUS REV FOR REFERENCE); 6.825 WAS 6.450 (ZN B7-1); 0.83 WAS 0.45 (ZN C8-2). REASON: PART11-124.	MB	11.10.25
C	D3256-041 ELIMINATED; REMOVED (QTY.22) 0.128 HOLES FROM D3256-1F AND D3256-3 GASKET. INSTRUCTIONS TO DRILL HOLES AND INSTALL D3256-3 GASKET ARE NOW PART OF THE INSTALLATION INSTRUCTIONS	MB	07.09.26
B	D3256-3 DIM 1.30 WAS 0.65	RF	05.06.27
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.25		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3256** REV. D
SHEET 1 OF 2
TITLE **ACCESS PANEL** SCALE NTS

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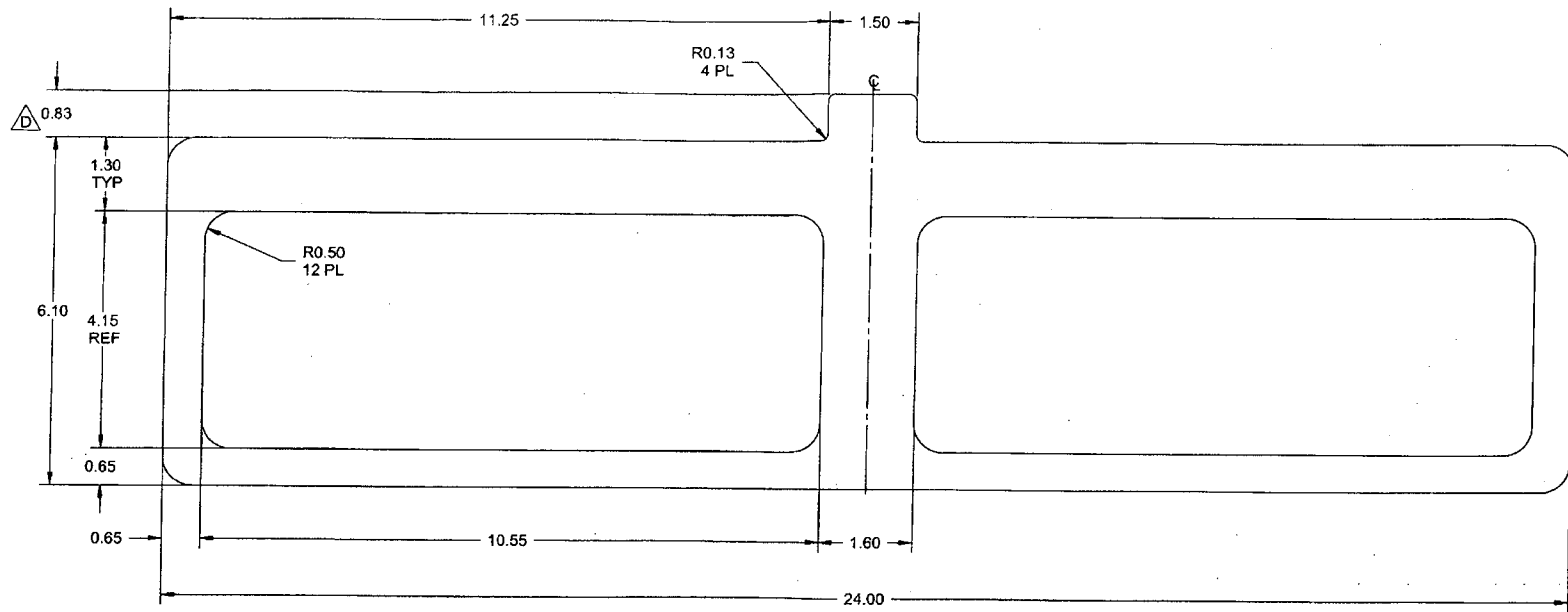
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8 7 6 5 4 3 2 1

es708



D3256-3 GASKET

RELEASE
2011-11-10
W

- NOTES:**
- 1) MATERIAL: DURABLA BLACK GASKET 0.035 THICK
PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A OR AMS 3232
REF. DART SPEC. MDURAS.035
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.08 lbs

DESIGN		DART AEROSPACE LTD.	REV'D
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	SHEET 2 OF 2
MFG. APPR.		D3256	
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL	UNITS
DATE	11.10.25	COPYRIGHT © 2004 BY DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

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